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D119-646-043
Job Sheet 166537



Part No: D119-646-043

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/4/17

Job Tracking No:

Due Date: 10/13/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG IIN-D119-646 REV D, D3905-041 REV E SHEETS 1,2,5,6, 8-14 IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/12/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/12/17	0.00	0.00	DC	
110	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	
120	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish1	
130	QC	1 pcs	10/12/17	0.00	0.00	QC7	
140	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9
170	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	3.68 DAS
180	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9
190	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	DAS 3.68
200	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9 DAS
210	QC	1 pcs	10/12/17	0.00	0.00	QC10	PD 9.80 9
220	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish2	PD 2017/10/19 1.56
230	SprayPaint	1 pcs	10/12/17	0.00	0.42	Spray Paint	DI 17-11-02
240	QC	1 pcs	10/12/17	0.00	0.00	QC14	DI 17/11/02
250	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish4	DI 17/11/02
260	QC	1 pcs	10/12/17	0.00	0.00	QC5	
270	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish4	DI 17/11/16
280	QC	1 pcs	10/12/17	0.00	0.00	QC5	
285	HandFinish	1 pcs	10/13/17	0.00	1.56	HandFinish3	DI 17/11/16
286	QC	1 pcs	10/13/17	0.00	0.00	QC5	
290	Packaging	1 pcs	10/13/17	0.00	0.00	Packaging3	
300	QC21-FG - Give to Plex core group	1 Ea	10/13/17	0.00	0.00	QC21	DAS 21 MAR 2 2019

Part Op 100 - Photocopy bluefile & type labels per PPP D119-646-043 CHG 005

Descriptions: 110 - 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Cut FWD end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9480 8- Drill FWD cap holes using DT8215.

170 - Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015.

(at 42.95" ref.) A/R Sikaflex-291 _____ Sikaflex expire date: _____ Start: _____ Time: _____

Finish: _____ Time: _____ ***** (Adhere for 12 hours) ***** 2--Bend AFT end of tube using

CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web

Work Order: _____ Part No. _____ NCR No. _____		Date: _____ Step #: _____		Description Work Order I		Date: _____	
DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	
AGAINST DEPARTMENT/PROCESS				MRB (Q51042) Approval			
Completed By				Lead hand / Supervisor Approval Verification			
QC / QA Coordinator Approval				PART NO: D119-646-043 Revision: Operation: QC Quantity: 1 Next Op: 140 QC			
SERIAL NO: S000401				Job #: 166537 Mfg Date: 10/12/17			
AW119 Replacement Skidtube with Wearpads, Float Compatible – Fits LI							

W I P

OCT17

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

Finish ☐

Misread ☐

Turning Sequence ☐

Wrong Stock Pulled ☐

Out of Sequence ☐

Off-set ☐

Mislabeled ☐

Fit/Function ☐

Misaligned/off center ☐

Inspection Incomplete/Unqualified ☐

Contamination ☐

Countersink ☐

Cut Too Short ☐

Instructions Incomplete/Unclear ☐

Drill Holes ☐

Crimp/Kink/Ripple/Wave ☐

Crushing ☐

Heat Treat ☐

Wave/Twist in Tube ☐

Marks/Chatter ☐

OTHER: _____

Root Cause

☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
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position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Debur crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & D

190 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Debur & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Debur and identify cap with skidtube batch#.

200 - TEST FIT USING FIXTURE DT10091.

220 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

230 - *****AS PER DETAIL"F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: ~~138637~~ PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138637 138708

250 - 1-Install inserts as per Dwg D3905.

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____

Sikaflex expire date: _____ 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6- Install (2)D5101-041 and (1) D5101-047 as per dwg by using DT10117

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-190 <u>B159717</u>	1	0	0	0
170-Skidtubes	D3885-3 <u>B154332</u>	1	0	0	0
190-Skidtubes	D2579 <u>B162087</u>	2	0	0	0
	D2855-5	1	0	0	0
	D3681-1 <u>B165379</u>	8	0	0	0
	D3903-1 <u>B163905</u>	12	0	0	0
250-HandFinish <u>500 8451</u>	ALS4-1032-130 <u>5007389</u>	42	0	0	0
	D3683-3	12	0	0	0
270-HandFinish	ALS4-1032-225 <u>F1113598212</u>	0	0	0	0
	AN3C4A <u>5000533</u>	6	0	0	0
	AN3C5A <u>5001919</u>	38	0	0	0
	AN4C46A <u>F11137214</u>	3	0	0	0
	D2855-3 <u>F133291</u>	1	0	0	0
	D3492-5 <u>F162345</u>	16	0	0	0
	D3672-1 <u>F1500711</u>	2	0	0	0
	D3672-3	12	0	0	0
	D3847-1 <u>F16215585</u>	8	0	0	0
	D3847-11 <u>F162014</u>	1	0	0	0
	D5101-041 <u>F140171</u>	2	0	0	0
	D5101-047 <u>50600833</u>	1	0	0	0
	D5101-3 <u>F158939</u>	6	0	0	0
	D5101-5 <u>F158786</u>	6	0	0	0
	MS21043-4 <u>F1167170</u>	3	300	0	0
	MS24694-C52 <u>F11137951</u>	2	100	0	0
	MS27039C4-08	12	0	0	0
	NAS1149C0332R <u>5001036</u>	44	0	0	0
	NAS1149C0463R	12	0	0	0
	NAS1611-005 <u>5007808</u>	16	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				



Traveller Change Request

Part#: _____

Job#: _____

Name _____

Date _____

Workcenter _____

Operation # _____

Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____

Name _____

Date _____

Workcenter _____

Operation # _____

Issue: Quality ☐

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Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____

D119-646-043 REV.E B

Seq.; 110

1- Bend FWD end of tube using Bender 1 and bend prog. D3905 FWD per dwg. D3905 (FOLIO -04)

2- Cut FWD end of tube as per dwg D3905.

3- Cut AFT end of tube as per dwg D3905.

4- Buff out marks left from bending

5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only.

6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.

7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9480

8- Drill FWD cap holes using DT8215.

Seq120; Alodine

Seq.; 130 Qc7 BE 17-10-10

Seq.; 140 Qc5 BE 17-10-10

Seq.; 170

Open FWD Saddle holes to finish size as per dwg and deburr

1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.)

A/R

Sikaflex-291

138.535

Sikaflex expire date:

2018-04-21

15.30

Start: _____ Time: _____

Finish: _____ Time: _____

***** (Adhere for 12 hours) *****

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position.

3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg.

4- Drill Tow ring hole using DT10047. Open to finished size.

5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C"

6- Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15:21")

7- Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube

8- Drill holes for wearpads using DT9613 & DT9545 open to 0.297". Deburr.

9- Buff out marks left from bending.

10- Pilot drill and Open holes of section G using DT9493 open to finished size.

11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

Seq.: 180 Qc5

BE 17-10-11

Seq.: 190

MGG
17/10/11

NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091.

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod _____

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3905.

4- Deburr & Scribe batch # on Aft end of tube.

5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

Seq.: 200 Qc5

Seq.: 210 Qc10

Seq.: 220

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Seq.: 230

*****AS PER DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT*****

PRIME AS PER DWG AND QSI 005 4.2

BATCH: _____

PAINT WHITE AS PER DWG AND QSI 005 4.2

BATCH: _____

Seq.; 240 QC14

Seq.; 250

1-Install inserts as per Dwg D3905.

Seq.; 260 Qc5

Seq.; 270

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/R Sikaflex-240/-291 _____

Sikaflex expire date: _____

2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: _____

3 -Inspect for foreign objects as per QSI 024

4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291 _____

Sikaflex expire date: _____

5 -Install insert in D2855- Cap.

Install cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291 _____

Sikaflex expire date: _____

6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117

Seq.; 280 Qc5

Seq.; 285 Wing Walk

Seq.; 286 Qc5

Seq.; 290 Packaging

Seq.; 300 Qc21

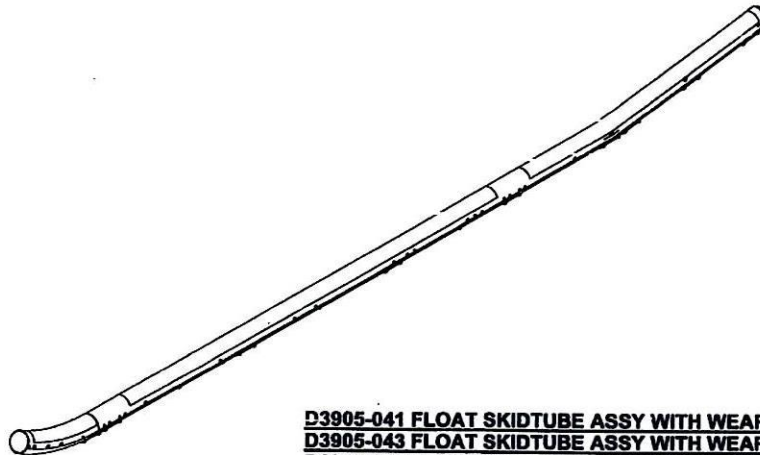
Status	Item ID	Rev	Name	Start Date	Quantity	PeUOM	Scrap %	Route Seq	ILComment	Sort	ate Last Mo	Add Date	Stop Date
	NAS1611-005		O-RING	4/20/2011	16.0000	E...	0 %	270		5	3/20/20...	4/20/...	
	NAS1149C0463R		Washer	3/20/2013	12.0000	E...	0 %	270		19	2/13/20...	3/20/...	
	NAS1149C0332R		WASHER	3/20/2013	44.0000	E...	0 %	270		18	2/13/20...	3/20/...	
	MS27039C4-08		SCREW	6/25/2009	12.0000	E...	0 %	270		20	3/20/20...	12/5/...	
	MS24694-C52		SCREW	3/20/2013	2.0000	E...	0 %	270		21	2/13/20...	3/20/...	
	MS21043-4		Nut	1/19/2015	3.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-5		Insert	1/19/2015	6.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-3		Insert	1/19/2015	6.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-047		Crossbolt Spacer Assembly	11/2/2016	1.0000	E...	0 %	270		0	11/2/20...	11/2/...	
	D5101-041		Crossbolt Spacer Assembly	1/19/2015	2.0000	E...	0 %	270		0	11/2/20...	1/19/...	
	D3903 1		Spacer	12/5/2009	12.0000	E...	0 %	190		13	3/20/20...	12/5/...	
	D3885-3		Float Web	12/5/2009	1.0000	E...	0 %	170		12	3/20/20...	12/5/...	
	D3847-11		Wearpad	12/5/2009	1.0000	E...	0 %	270		11	3/20/20...	12/5/...	
	D3847-1		Wearpad	12/5/2009	8.0000	E...	0 %	270		10	3/20/20...	12/5/...	
	D3683-3		Insert	12/5/2009	12.0000	E...	0 %	250		15	3/20/20...	12/5/...	
	D3681-1		Spacer	12/5/2009	8.0000	E...	0 %	190		7	3/20/20...	12/5/...	
	D3672-3		Washer, Phenolic	3/20/2013	12.0000	E...	0 %	270		14	2/13/20...	3/20/...	
	D3672-1		Washer, Phenolic	12/5/2009	2.0000	E...	0 %	270		6	3/20/20...	12/5/...	
	D3492-5		Plug	4/20/2011	16.0000	E...	0 %	270		4	3/20/20...	4/20/...	
	D2855-5		Cap	5/23/2017	1.0000	E...	0 %	190		0	5/23/20...	5/23/...	
	D2855-3		Cap	12/5/2009	1.0000	E...	0 %	270		3	5/23/20...	12/5/...	
	D2579		Crossbolt Spacer	11/5/2012	2.0000	E...	0 %	190		2	2/13/20...	11/5/...	
	D2500-1-190		Ext'n - 1" Beam Tube 4" <i>B159 717</i>	12/5/2009	1.0000	E...	0 %	110		1	12/5/20...	12/5/...	
	AN4C46A		Bolt	1/19/2015	3.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	AN3C5A		Bolt	6/25/2009	38.0000	E...	0 %	270		17	11/2/20...	12/5/...	
	AN3C4A		Bolt	11/2/2016	6.0000	E...	0 %	270		0	11/2/20...	11/2/...	
	ALS4-1032-225		Rivnut	5/23/2017	1.0000	E...	0 %	270		0	5/23/20...	5/23/...	

Item ID: D119-646-043

ROM Type: Production

Status	Item ID	Rev	Name	Start Date	Quantity	Pct	UOM	Scrap %	Route Seq	IL	Comment	Sort	ate	Last Mo	Add Date	Stop Date
	ALS4-1032-130		Rivnut	6/25/2009	42.0000	E		0 %	250			16	3/20/20...		12/5/...	

REFERENCE ONLY



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

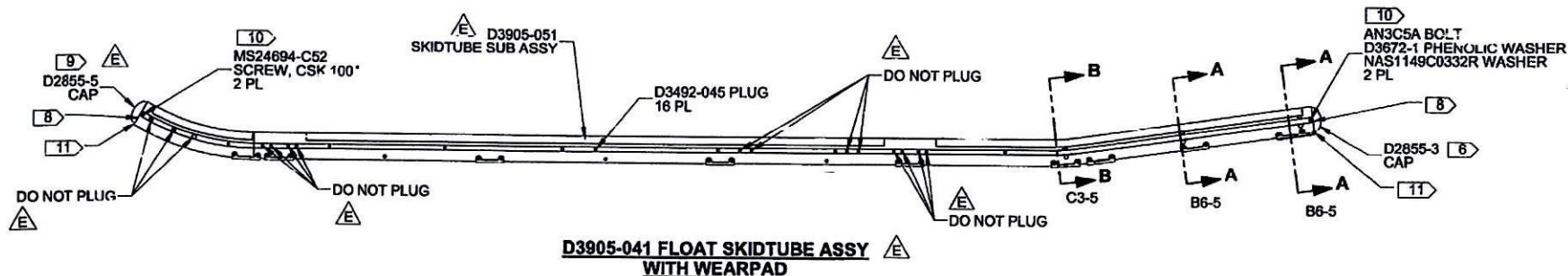
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.485 WAS Ø0.437. FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PART15-421. CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-6 CAP. REF PART17-583. ADDED DRILL JIG REF NUMBER, NCR15-5386. INCREASE RIDGE RELIEF FROM 0.080 TO 0.130. REF PART17-574.	AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-6. REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B8, ZN A8-1). REVISED -041/-043/-045 DRAWING VIEWS, REVISED SECTION VIEW F-F (ZN B4-7). REVISED BOM REF. PART13-299 AND PART13-272.	AK	14.08.08
C	(SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4. ITEM 42 AND 43, QTY 44 WAS 46. ADD ITEM 48, MS24884- CS2 WAS AN3C5A, D3672-1 AND NAS1148C0332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CRUSS BOLT SPACER (ZN D4-1, C6-7, D8-7).	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A8-6, C5-7, C3-7, A5-7). ADD DT8832 (ZN A8-1). D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4). AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4). D3848-041 WAS D3848-041 (ZN B3-4). ADD D3411-3 (ZN B3-4). ADD AN3C50A (ZN B3-4). 2.0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-9), REVISED NOTE IV (ZN A8-7).	RF	08.06.30
A	NEW ISSUE	RF	08.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 1 OF 14
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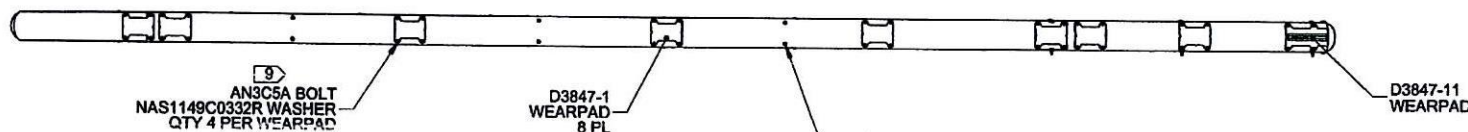
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	5	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C48A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



**D3905-041 FLOAT SKIDTUBE ASSY
WITH WEARPAD**



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 35.4 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\varnothing 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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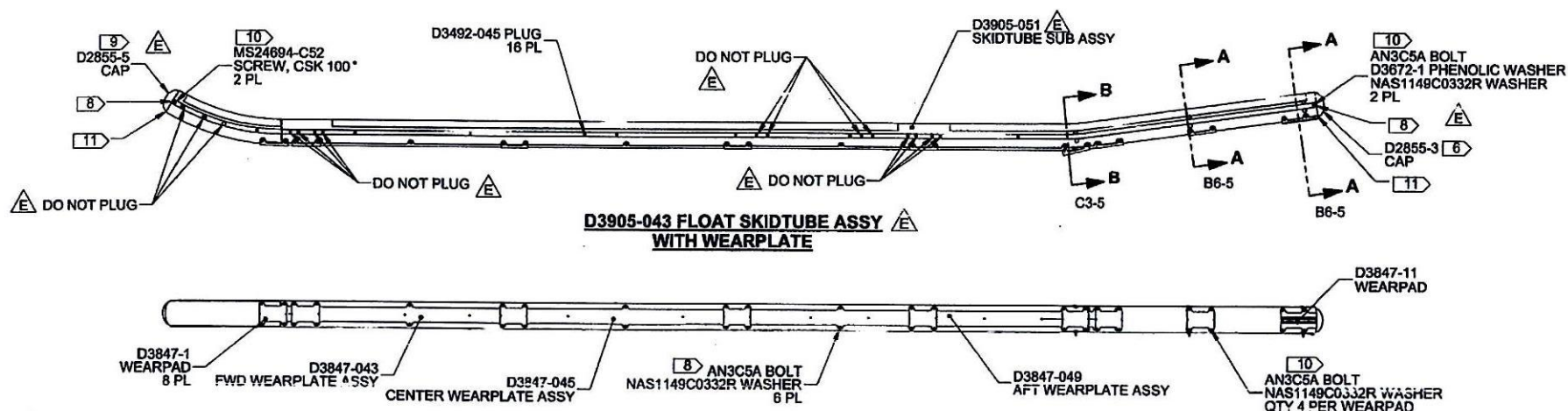
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A119 FLOAT SKIDTUBE ASSY

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3905-043	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	FLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-049	AFT WEARPLATE ASSY
8	8	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3905-051	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSSBOLT SPACER ASSY
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -043	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	44	AN3C5A	BOLT
17	3	AN4C46A	BOLT
18	3	MS21043-4	NUT, SELF-LOCKING
19	2	MS24694-C52	SCREW, CSK 100*
20	44	NAS1149C0332R	WASHER
21	6	NAS1149C0416R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 42.8 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$. ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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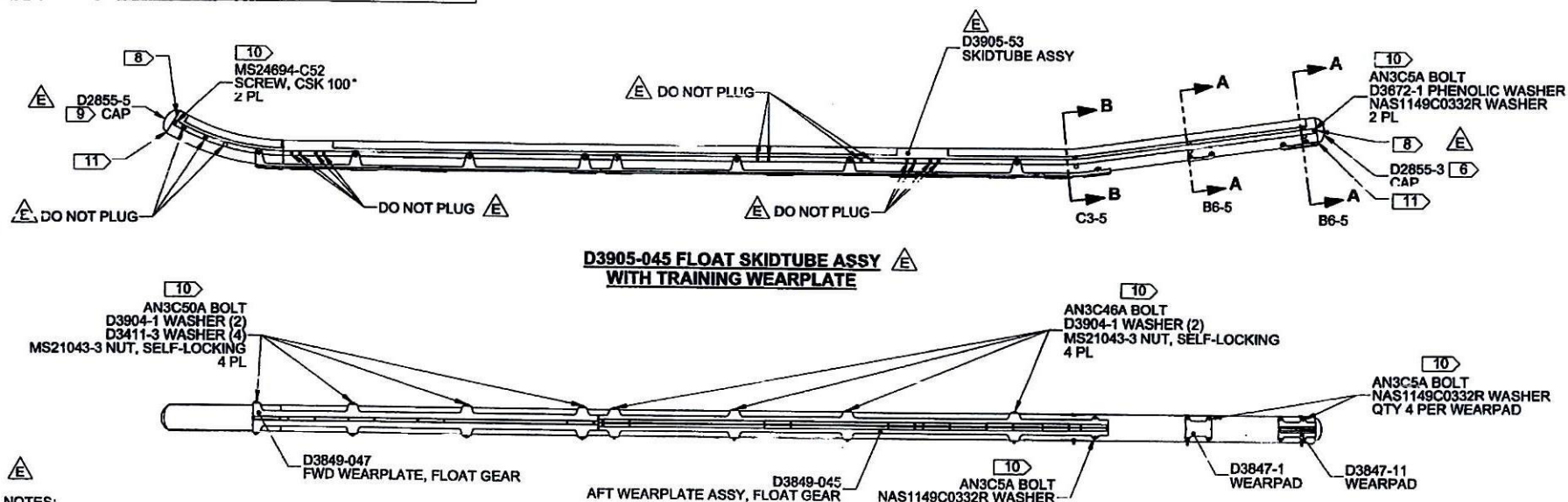
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	16	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 48.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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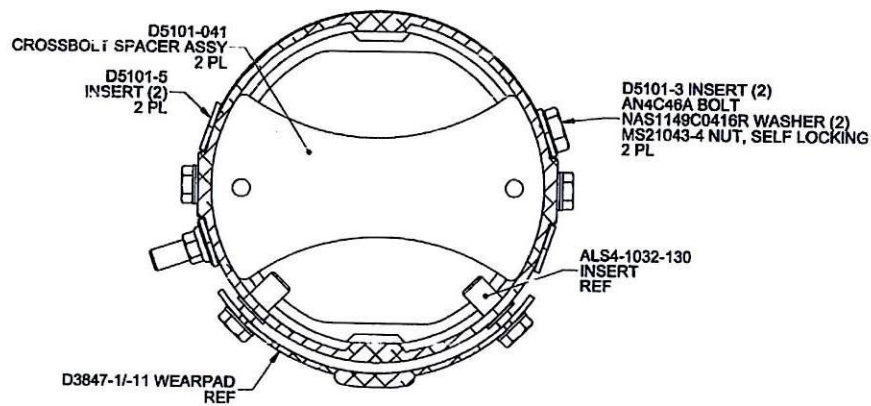
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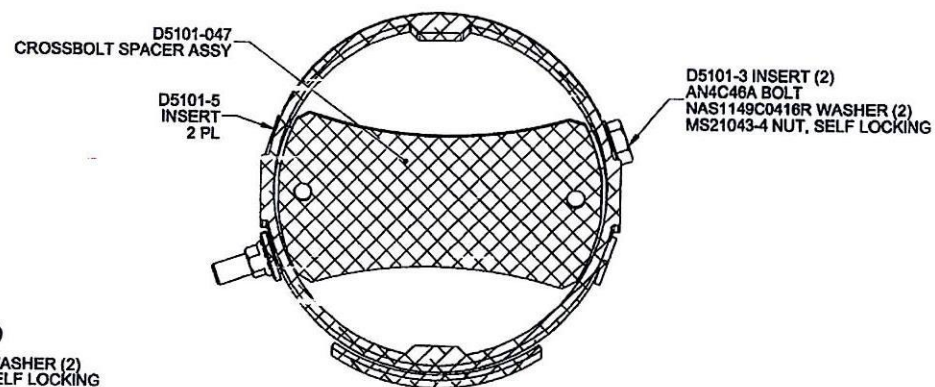
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SECTION A-A
SCALE: 12X



SECTION B-B
SCALE 12X

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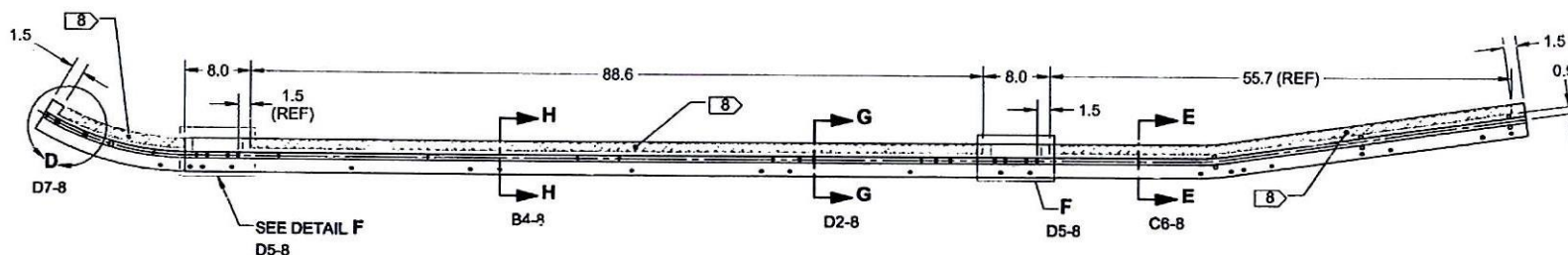
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ITEM	QTY -051	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

NOTES:

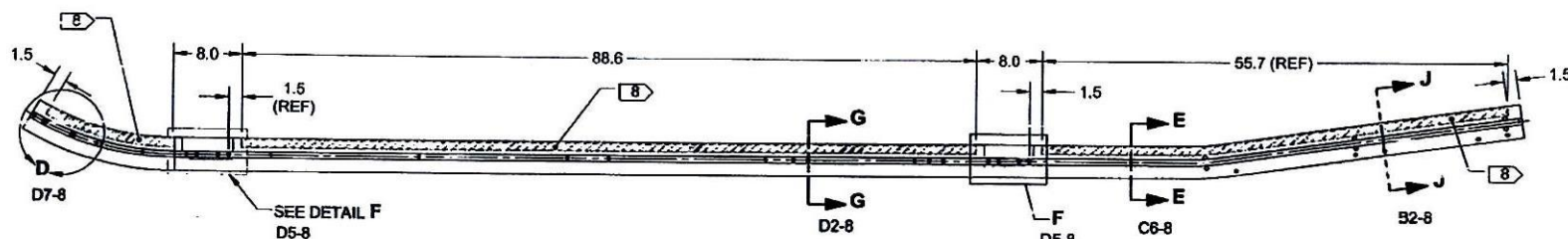
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- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

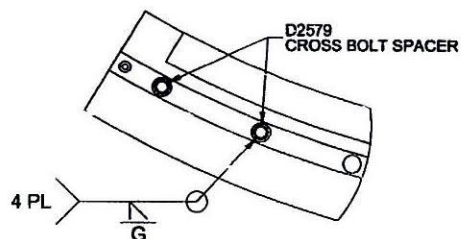
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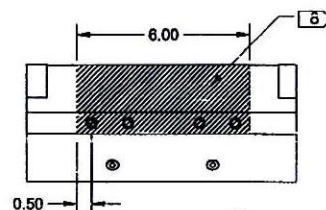
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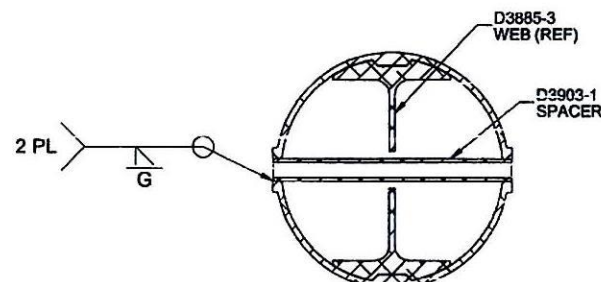
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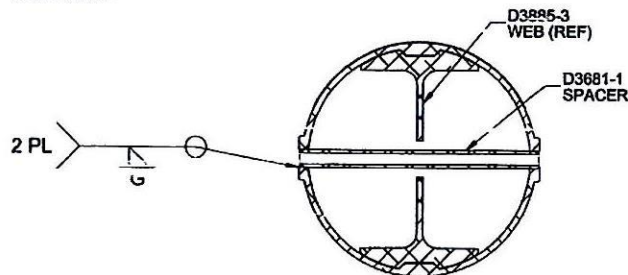
DETAIL D
SCALE: 3.5X



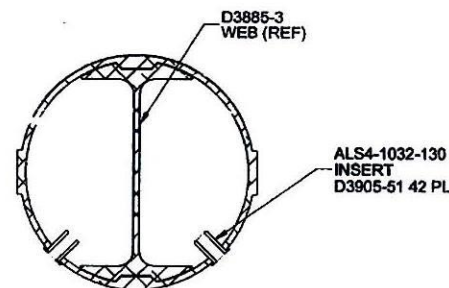
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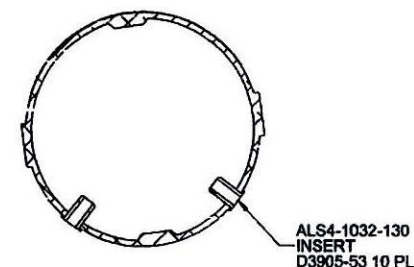
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) CBORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

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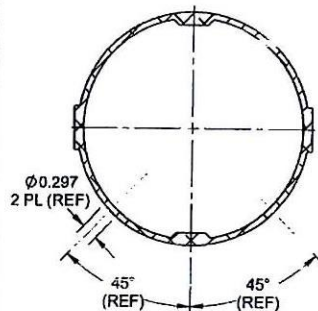
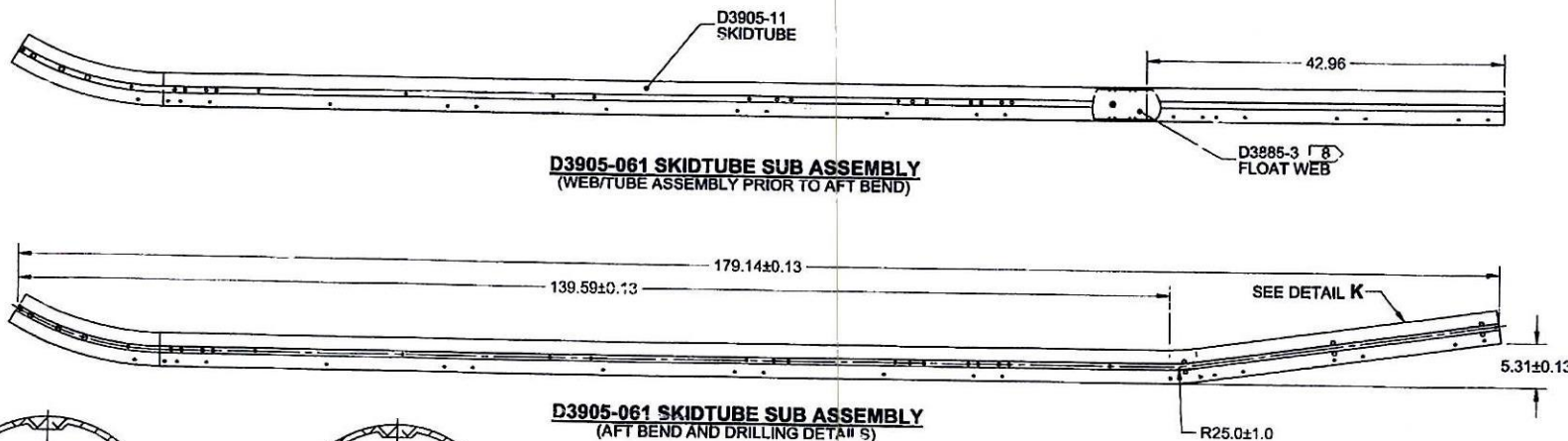
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SHEET 8 OF 14
TITLE **A119 FLOAT SKIDTUBE ASSY** SCALE NTS

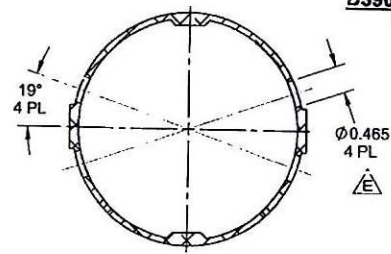
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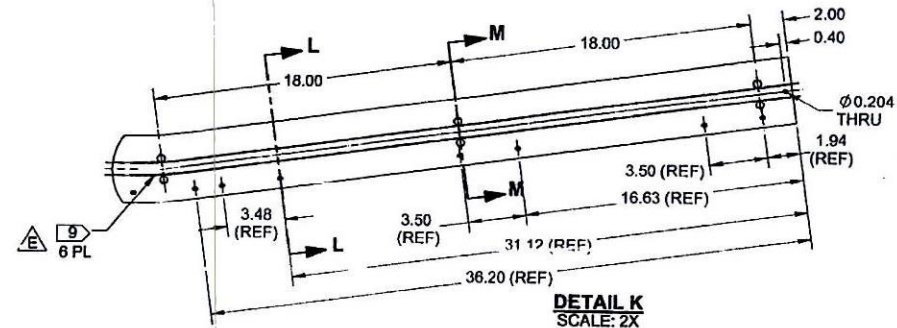
ITEM	QTY	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



SECTION L-L
7 PL
SCALE: 7X



SECTION M-M
3 PL
SCALE: 7X



DETAIL K
SCALE: 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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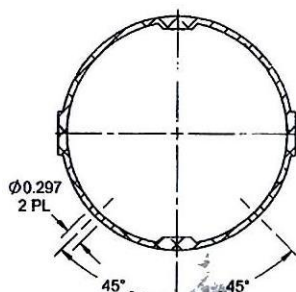
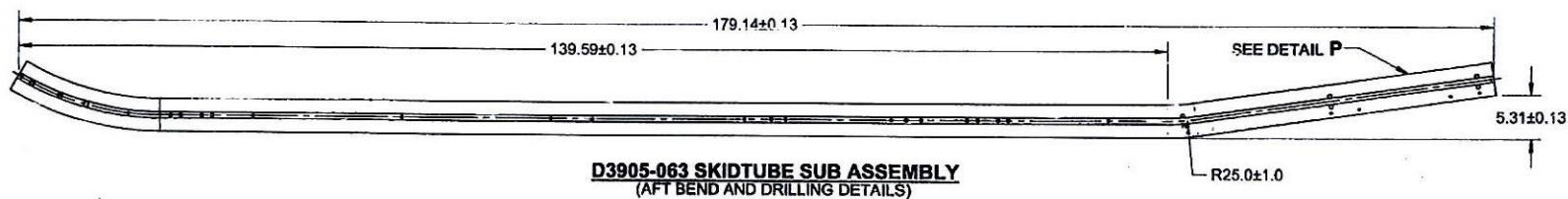
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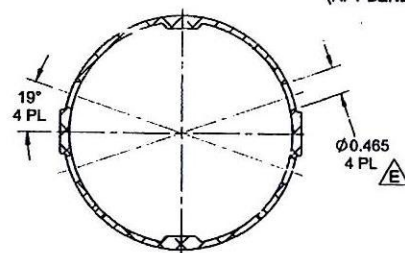
DRAWING NO.	D3905	REV. E
TITLE	A119 FLOAT SKIDTUBE ASSY	SHEET 9 OF 14
SCALE	NTS	

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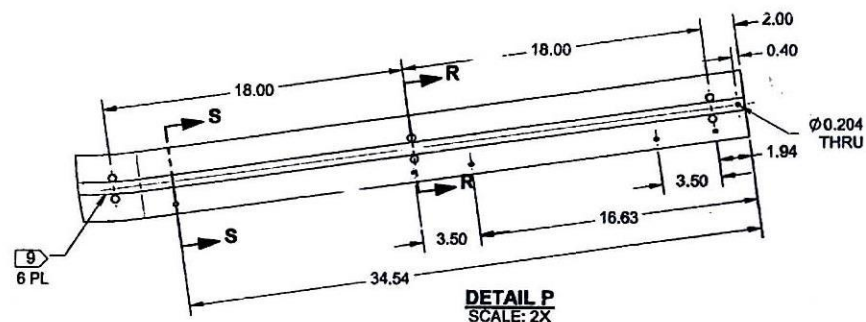
ITEM	QTY	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



SECTION S-S
5 PL
SCALE: 7X



SECTION R-R
3 PL
SCALE: 7X



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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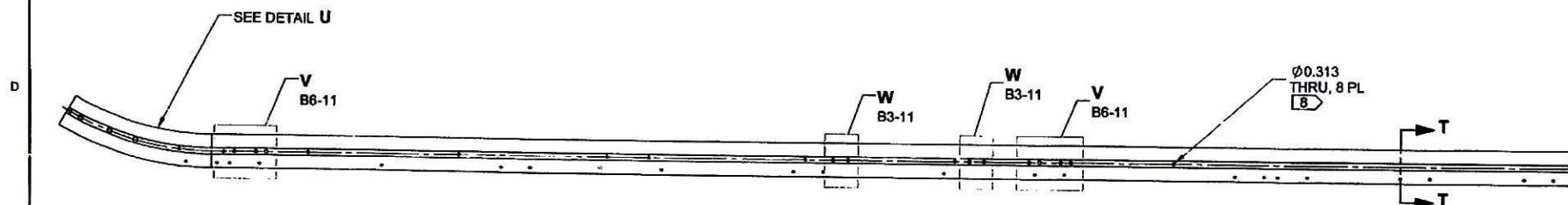
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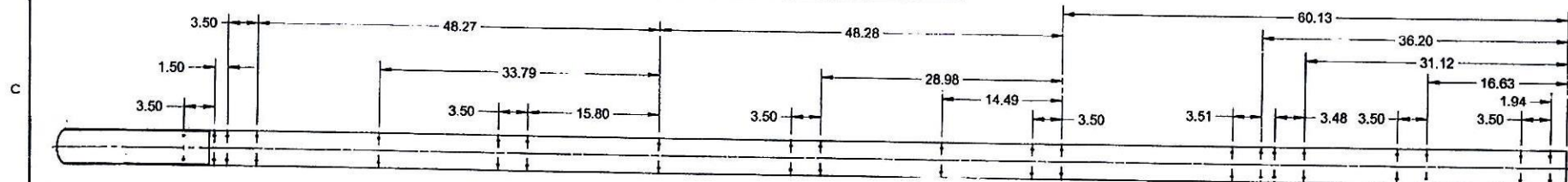
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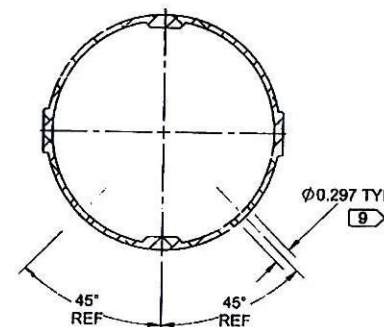
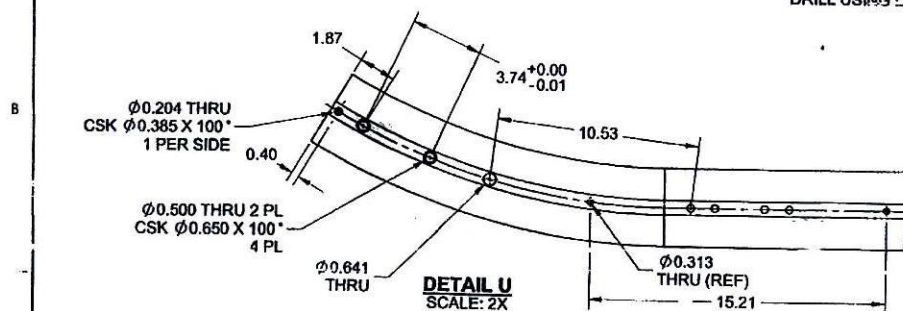


D3905-11 SKIDTUBE DRILLING DETAIL



WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT9613/DT9545 TEMPLATE

△ E



SECTION T-T
SCALE: 2X
21 PL

△ E

NOTES:

- 1) MATERIAL: MAKE -11 DRILL DETAIL FROM -1 FWD BEND DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) PICK UP ON PILOT HOLES
- 9) USE DART DRILL TEMPLATE DT9613/DT9545 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPAD/WEARPLATE INSERTS.

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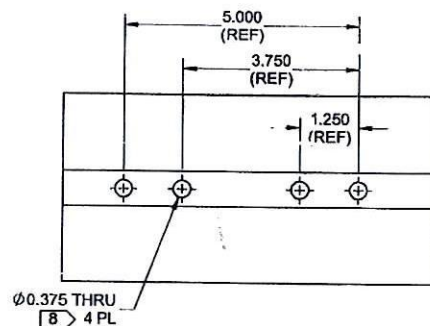
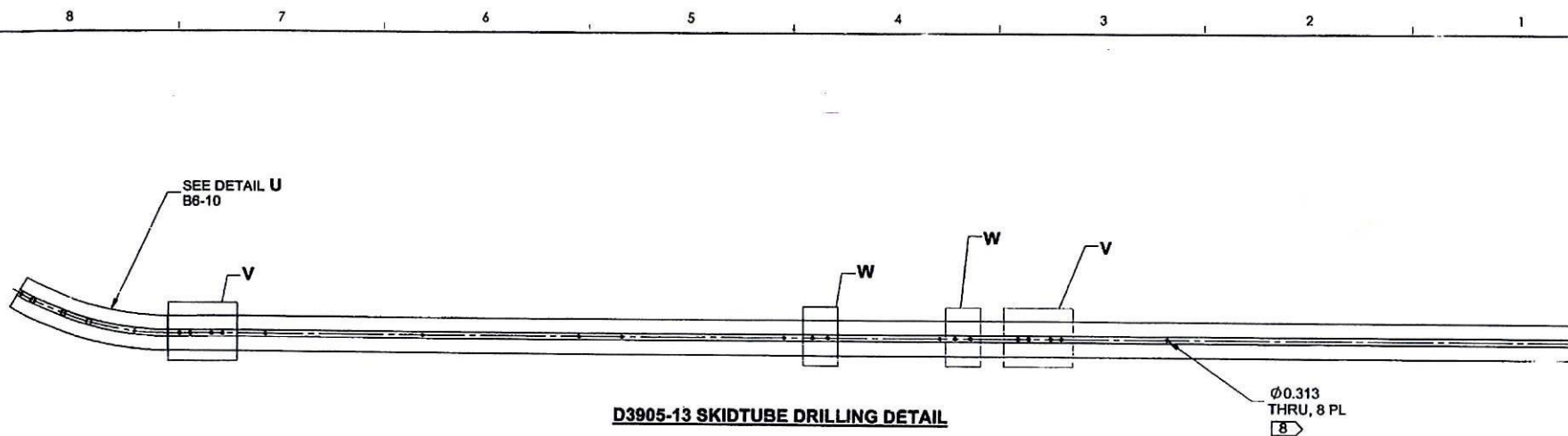
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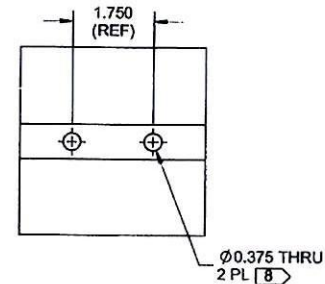
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TITLE **A119 FLOAT SKIDTUBE ASSY** SCALE NTS

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8 7 6 5 4 3 2 1



DETAIL V
SCALE 4X
2 PL



DETAIL W
SCALE 4X
2 PL

NOTES:

- 1) MATERIAL: MAKE -13 DRILL DETAIL FROM -1 FWD BEND DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) PICK UP ON PILOT HOLES

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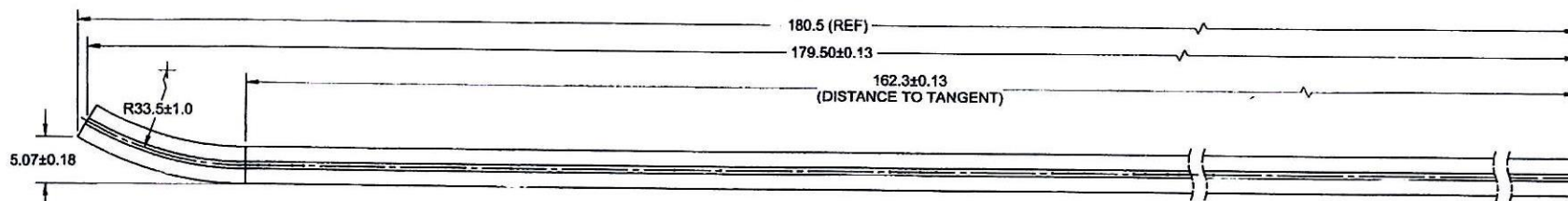
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D3905-1 SKIDTUBE FWD BEND DETAIL

NOTES:

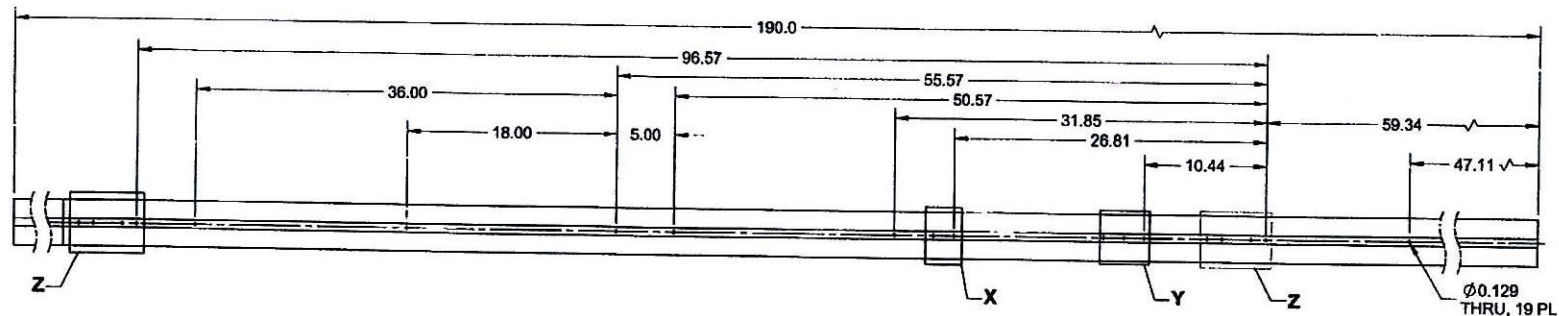
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

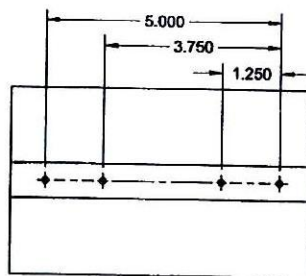
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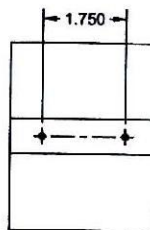
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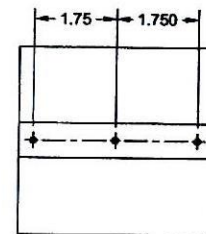
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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